

Work Order ID 77455

77455

Page 1

December-07-11 2:54:40 PM

Item ID: D2037-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 07/12/2011 Start Qty: 6 ***10*** Cust Item ID:
 Required Date: 21/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2037	D

100 0.00
100 NC BRAKE
 Brake NC Memo 0.00
 Brake NC Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1 SB 12/6/12 (6)

110 0.00
110 Small Fab
 Small Fab Memo 0.00
 Small Fab 1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 2-Flatten
 ends of D2037-101 tube as required using DT8545
 3-Deburr as required SP 12-01-26 (6)

120 0.00
120 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control SP 12/6/13 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77455

77455

Page 2

December-07-11 2:54:41 PM

Item ID: D2037-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 07/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 21/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12-02-2
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-07-11 2:54:44 PM

Page 1

Work Order ID: 77455

77455

Parent Item: D2037-101

D2037-101

Parent Item Name: Arm

Start Date: 07/12/2011

Required Date: 21/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-01 JLM
IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

110

f

332.1191

3.916

41.22105

M304TR0 750W 049

**

JB 12/01/23

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT017

332.11913

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117797

0.75

117983

7.091

118390

35.59263

119160

173.7695

119644

80

26

Dart Aerospace Ltd

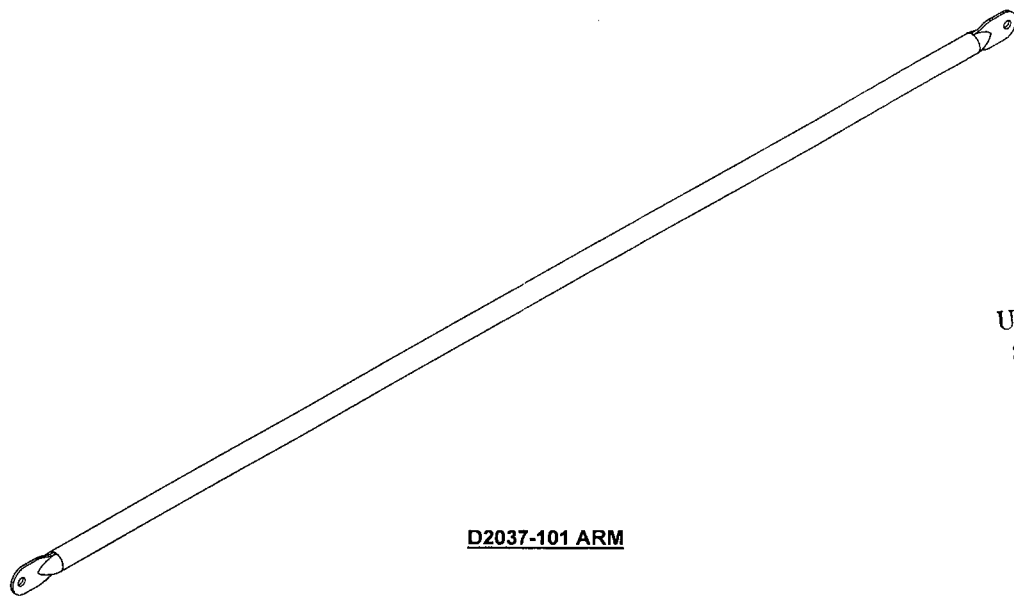
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D2037-101 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77455 M.C.D
11/12/07

RELEASED
08.05.07

NOTES:

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, $\phi 0.750 \times 0.049$ WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

D	INCORPORATED C1,C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D2037 REV. D SHEET 1 OF 2	
DATE	08.05.08	TITLE ARM SCALE NTS	
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Dart Aerospace Ltd

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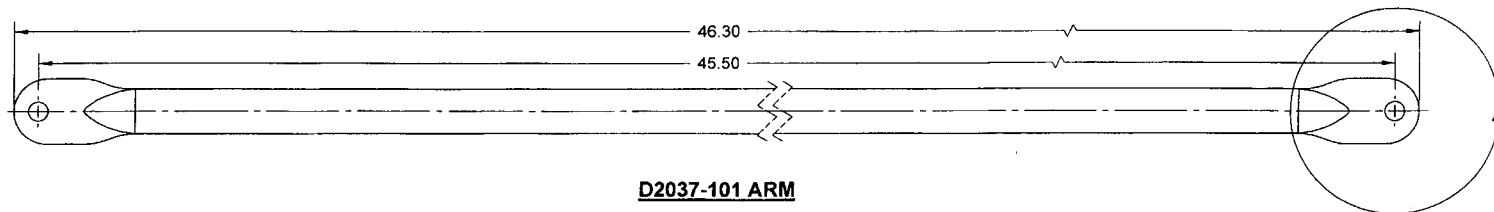
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

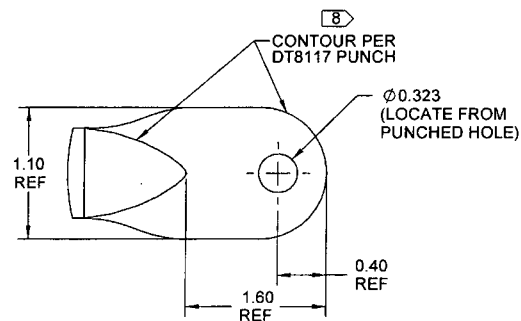
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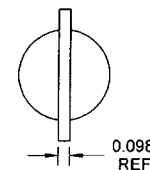
77455



D2037-101 ARM



DETAIL A
SCALE 2X
2 PL



RELEASED
06-07-01 WAD

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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